

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025848**Date Inspected:** 02-Jul-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006	Component:	OBG Components				

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for observations relative to the work being performed.

Blast Shop 4

This QA Inspector and QA Inspectors Mike Hasler, Kelly Bennet, Vikram Singh responding to phone notification from ABF Inspectors performed a pre-final sandblast inspection of Segment 13AW, south (crossbeam) side between panel point 118 and panel point 119-1500, from 1 meter below the deck plates down to but not including the bottom plate or side plate. This QA Inspector observed several surface irregularities requiring grinding. These areas were marked for grinding. This QA Inspector observed several surface irregularities appearing to be arc strikes requiring grinding and magnetic particle testing (MT). These areas were marked for grinding and MT. This QA Inspector also observed 3 welds not completed to the end of the I-rib to longitudinal diaphragm connection. The welds were designated as LD3031-087, LD3031-088, SEG3013AP-040 and they appeared to require weld repair. The weld repairs were documented and reported in a Post Blast Repair Report of this date. See that report for further details.

Blast Shop 2

This QA Inspector and QA Inspectors Paul Dawson, Kelly Leavitt responding to phone notification from ABF Inspectors attempted to perform a pre-final sandblast inspection of Segment 14W, in the anchor plate area. This QA Inspector observed several areas where the rust was thick on the plates and the welds making inspection of the surface irregularities and welds difficult, if not impossible. This QA Inspector informed ABF Inspector Stone that the conditions of the area to be inspected were unacceptable.

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Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet, George	Quality Assurance Inspector
Reviewed By:	Riley, Ken	QA Reviewer
